

U.S. Ser. No. 09/143,503
U.S. Control No. 90/004,946

Exhibit 25

ADVANCED CARDIOVASCULAR SYSTEMS
EXTRUSION DATA SHEET

START TIME: EXTRUSION #: 10-569-1 AMOUNT (FEET): 100'
FINISH TIME: DATE: 11-16-94 SIGNATURE/DATE MM 11-16-94

MATERIALS :	MATERIAL DESC.	LOT# :	RM#
PEAK	Sample Material	N/A	N/A

EXTRUDER 10 PROCESS PERSON TTOMAS

REQUESTOR J.LEE

PRODUCT SHAFT SA#

SET-UP PARAMETERS:

MANDREL LGTH (EXT ONLY)	FLUSH	EXPERIMENTAL Y
DIE I.D. .110	OVAL N	PRODUCTION N
MANDREL O.D. .072	XHEAD Y	STRAIGHT N
SCREW TYPE SC 110393-1		
SCREEN TYPE 20 100		
START ID/OD .032/.038		
FINISH ID/OD .032/.038		

PROCESS PARAMETERS

TEMPERATURE SETPOINTS	SPEEDS & SETPOINTS	PSI & AIR
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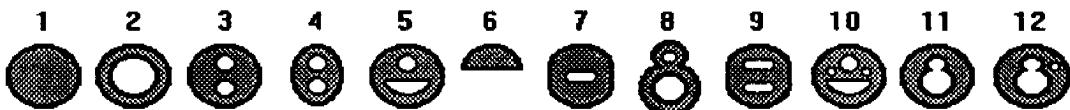
ZONE 1 700.0 MELT	800.0 SCREW RPM	7.5 HEAD PSI 2569.0
ZONE 2 750.0 DIE	1 0.0 PSI SET 208.0	DIE PSI 2198.0
ZONE 3 750.0 DIE	2 0.0 EXTR. AMP 35.8	AIR PSI 1 5.5
CLAMP 760.0 DIE	3 750.0 PUL SPEED 43	2 0.2
INLET 775.0 W/B TEMP	R/T 0.0 W/B DIST. .75	3 0.3
G/PUMP 32.0		4 0.4
PMP OUT 750.0		
XHEAD 0.0		

MATERIAL DRYING TMP. 300°F DEWPOINT -54 # OF HRS DRYING 4.6 hrs

ACTUAL PARAMETER COLLECTED EVERY 10 MINUTES

SETPOINT	ACTUAL 1	ACTUAL 2	ACTUAL 3	ACTUAL 4	ACTUAL 5
G/PUMP PSI					
PUMP AMP					
SCREW RPM					
EXTRUDER AMP					
PULLER SPEED					
BARREL 1					
BARREL 2					
BARREL 3					
HEAD PSI					
TUBING O.D.					
AVG.DIA.					
AVG.STD.DEV.					

*Extruder very unstable
could not get tubing
in size*



Request # 2,188

Request Date 4/19/94

Extrusion # 10-569-A

Date Closed

<u>Machine Setup</u>		<u>Tooling</u>	<u>Dimensions</u>					
Zone 1	700 F	<u>Die</u>	Tubing Profile = 02 (Single-Lumen)					
Zone 2	750 F	Dwg. #	High Wall					
Zone 3	750 F	ID / Shape .1100" (35)	Low Wall					
Clamp	F	Land Length Long	% Conc.					
Adapter	760 F	Material Stainless	Basis Wgt.					
Die Body	775 F	Comments Round						
Die Nut	750 F							
Brl Melt	800 F	<u>Mandrel</u>	<u>Setpoints</u>					
Flg Melt	F	Dwg. #	Nominal					
Die Melt	800 F	Style Hypotube	Upper					
Throat	F	Length 0.650"	Lower					
Brl Pres	2569 PSI	Extension Flush						
Flg Pres	PSI		<u>Statistics</u>					
Die Pres	2198 PSI	<u>Miscellaneous</u>	Avg. Xbar					
		Tubing Dwg. #	Avg. Sigma					
		X-Head Bolt-On	Avg. Cp					
		Screens 20/100/200/100/80/60/20	Avg. Cpk					
		Breaker Plate Single	Oval. Xbar					
<u>Screw</u>								
Speed	7.5 RPM	<u>Puller</u>	<u>Water Bath</u>					
Mode	Manual	Speed 43 FPM	Temp Ambient F					
Setting	(% / PSI)	Mode Manual	Air Gap 0.75 "					
Amps	35	Setting (%)	Flow 4 gph					
ID	1" SC110393-1 PE		Dam Iris					
<u>Materials</u>		<u>Drying</u>						
%	<u>Part #</u>	<u>Rev</u>	<u>Description</u>	<u>Lot #</u>	<u>Temp.(F)</u>	<u>Time (Hrs)</u>	<u>Dew Pt.</u>	<u>% Moist.</u>
100	VM-NEWKEY-1	A	PEAK	NONE				
<u>Statistic Comments:</u>								
<u>Machine Comments:</u>		This is an experimental run for Loproshaft. Many problems were encountered on this run surging, degradation, and instability no tubing was collected.						

